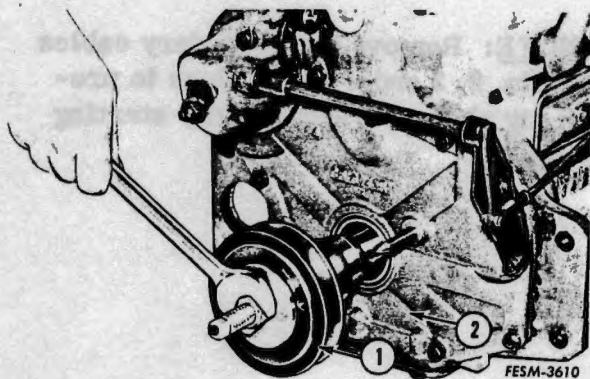


1. Fan drive pulley
2. Wear sleeve
3. FES 33-4 Fan drive pulley wear sleeve installer



1. Fan drive pulley
2. Crankcase front cover

3. Install the key in the crankshaft if it was removed. Heat the crankshaft gear and install the gear, being sure the single timing mark of the camshaft gear and the single mark on the crankshaft gear are aligned.

4. Install the idler gear and shaft. Tighten the bolt to 90 ft. lbs. torque. The idler gear is correctly timed by lining up the double punch mark on the idler gear with the double punch mark on the crankshaft gear.

NOTE: Before installing the crankcase front cover, mark the top surfaces of the two teeth on each side of the single punch mark on the idler gear with chalk.

5. Install the crankcase front cover with a new oil seal and gasket. Do not tighten the cap screws at this time.

NOTE: If necessary, install a new wear sleeve onto the fan drive pulley using the FES 33-4 fan drive pulley wear sleeve installer as shown. Be sure to apply a sealer onto the pulley O.D. or the I.D. of the wear sleeve before installing the wear sleeve onto the pulley.

6. Install the fan drive pulley (1) using installing tool, FES 33-1 as shown. It may be necessary to block the flywheel to prevent the crankshaft from rotating.

7. Tighten the front cover cap screws to 20 ft. lbs. torque. This permits the seal and the cover to be centered by the fan drive pulley hub and insures an even contact of the seal around the pulley hub.